

Split

Work Order ID 76219-2

76219

Page 1

November-07-11 2:38:37 PM

Item ID: D3207-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 07/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/08 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3207	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3207 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

B12-1-26

9

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-1-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

512/4/26

x9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76219

November-07-11 2:38:37 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 07/11/2011 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 21/11/2011 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: _____ Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

0.00

130

NC BRAKE

0.00

Brake NC

Brake-NC

Form 1/2 of stack for D3207-2 as per Dwg D3207/Identify as D3207-2

Sp 1261/31

140

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

QC

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Memo

0.00

HandFinish

Hand Finishing

W/O: 76219

~~76219~~

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3207-2

PAR #:

Fault Category: Small FAB

NCR: Yes No

DQA: ~~OK~~

Date: 12/2/3

Resolution: Scrap

Disposition: Scrap

QA: N/C Closed:

~~OK~~

Date: 12/3/2

NCR: 12-1177

WORK ORDER NON-CONFORMANCE (NCR) 37.42

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/31	130	1 part Scrap at the set up out of tolerance R.L. → operator error Re Process	12.01.31 QS1042	Scrap & destroy no replace	SN 12/01/31	S 12/01/31	12.01.31 QS1042	12/4/31

NOTE: Date & initial all entries

Work Order ID 76219

76219

Page 3

November-07-11 2:38:37 PM

Item ID: D3207-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 07/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	--	------	--	--	--	--	--	--	--

160
 Powdercoat
 Powder Coating

Memo
 START TIME: 10:20 OVEN TEMPERATURE:
 FINISH TIME: 10:50

170	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

170
 QC
 Quality Control

Memo

180	Identify as per dwg & Stock Location 202	0.00							
-----	--	------	--	--	--	--	--	--	--

180
 Packaging
 Packaging

Memo

6x4 m-f 12/02/01

6 A 12-B-1

12/2/25 (60)

m 11848a

3200F

10:20

10:50

202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76219***76219***

Page 4

November-07-11 2:38:37 PM

Item ID: D3207-2 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Bracket
Start Date: 07/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/2/2 DJ

P12-02-2 W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-07-11 2:38:41 PM

Work Order ID: 76219

76219

Parent Item: D3207-2

D3207-2

Parent Item Name: Bracket

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.04.15New issueKJ/RF
IPP Rev:B Now On Waterjet 08-01-02 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	83.1000	0.143	0.903158	1.5		
M2024T3S 050										**	KB 12-1-26		
2024-T3 .050 sheet													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT22		83.1					
						117684		83.1		117682			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

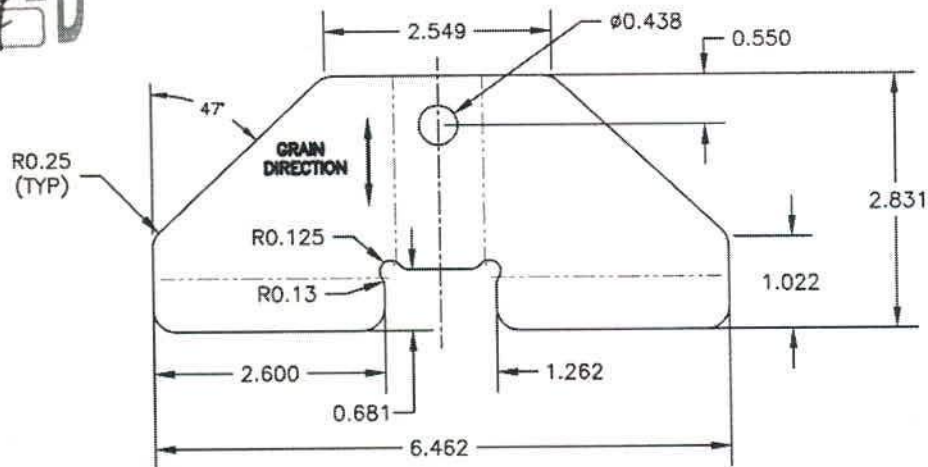
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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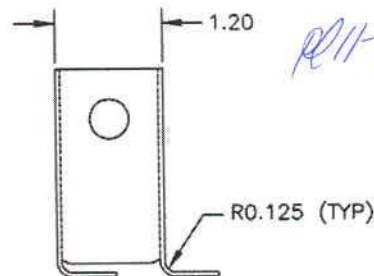
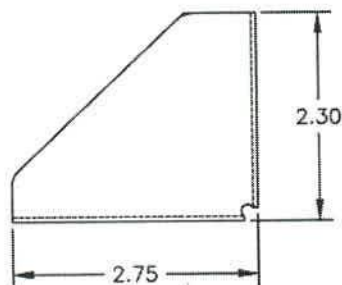
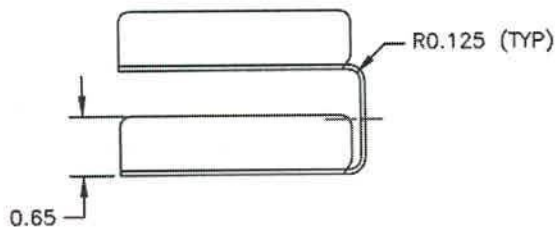
DART

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DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



D3207-1/-2 FLAT PATTERN



**D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE**

NOT FOR COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO
WITH
WORK
NO. 74219

R11-11-08

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

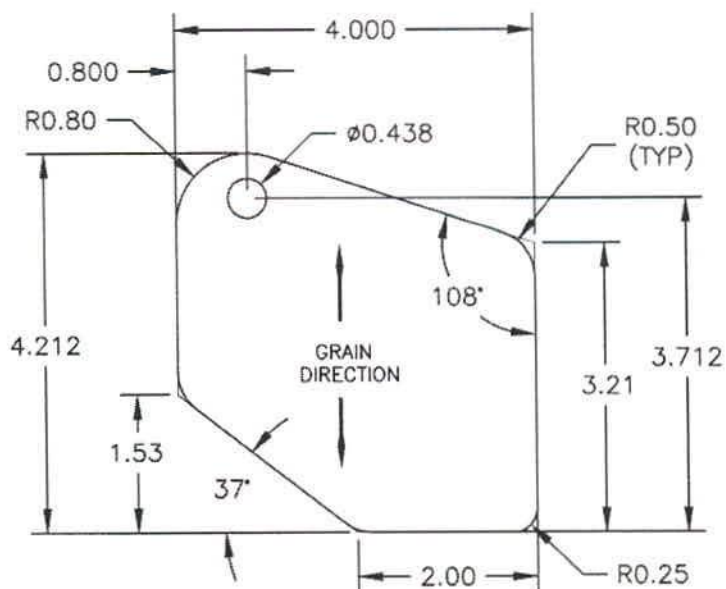
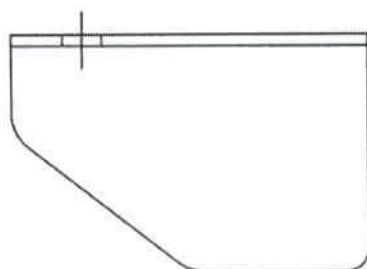
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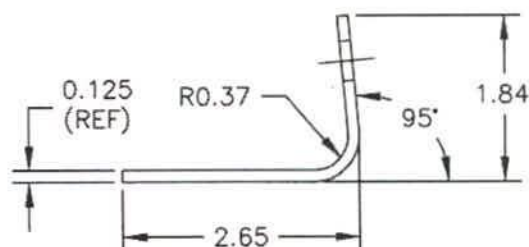
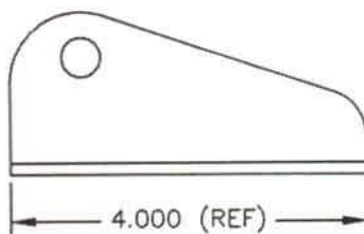


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DATE 04.01.27	TITLE BRACKET		SCALE 1:2

RELEASED
04.04.05 [Signature]



D3207-3 FLAT PATTERN



D3207-3 BEND DETAIL

D3207-3 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

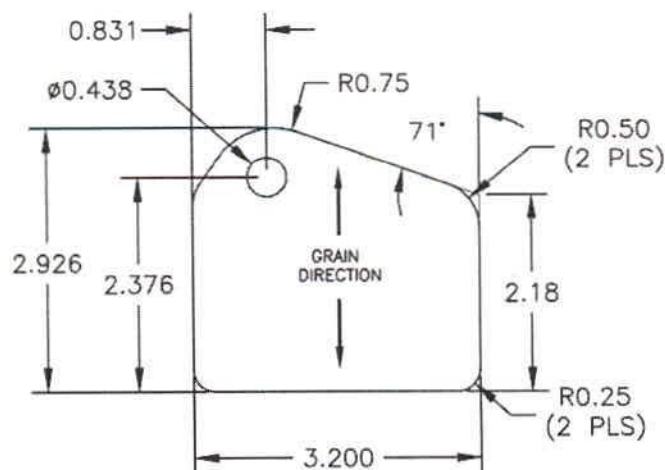
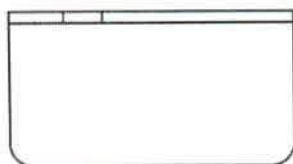
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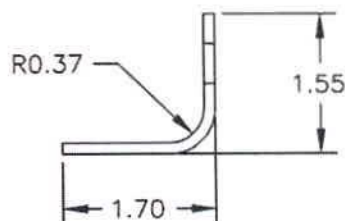
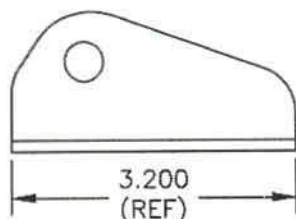


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CHECKED H	APPROVED H	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED
04.04.05



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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